

Date: Monday, 08/06/2009 9:26:04 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	350/212/130 BASKET LID
Job Number	48393B		Part Number	D2512
Estimate Number	10193		Drawing Number	D2512 REV E
P.O. Number			Project Number	N/A
This Issue	08/06/2009	S.O. No. :	Drawing Revision	E
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : LARGE FAB ASSY	Due Date	15/06/2009
Previous Run	48209A		Qty:	1
Written By	:		Um:	Each
Checked & Approved By	<u>Julie Dawson</u>			
Comment	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC Est Rev:O 08-08-29 revE as per dwg DD verified by:EC Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	257
	Pick: 3/4"x3/4" 304/316 SS tube .065" wall	2.57 = m112051
	Batch: <u>m111885</u> → <u>43,1894</u>	SAP 09-06-15 ①
✓ 2.0	D31663	Basket Hoop
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch	
	1 D3166-3 Basket Hoop <u>B412957</u>	SAP 09-06-16 ①
✓ 3.0	D2506	Label Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick: Qty Part Number Description Batch	
	1 D2506 Label Plate <u>B415735</u>	SM 09/06/18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

Job Number: 48393B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2327-1	Bushing	<u>B416325</u>

SLY 09/06/18

5.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	<u>48230</u>

SLY 09/06/18

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	<u>47264</u>

SLY 09/06/18

7.0 M304EX07516F Expanded Metal Flat SS



Scrap B# 111956 = 2 sf

Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	<u>#111956</u>

SAO 09-06-16

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

SAO 09-06-16

2-Cut (4) D2236 From D3166-3

SAO 09-06-16

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

SAO 09-06-16

5-Weld as per Dwg D2512 using Dt9436

SLY 09/06/18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09-06-18

10.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Do 9/06/18 (X)

11.0 POWDER COATING

POWDER COATING



M 111472

Comment: POWDER COATING

PRESSURE WASH 09-06-19 (X)

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 7:00AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 7:30AM

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

09 09-06-19 (X)

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1 X M 111301 / M 110907

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M 111013 9/09-06-19 (X)

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/06/19

14.0 PACKAGING 1

PACKAGING RESOURCE #1



(10)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 000 48393

9/06/19

SH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/19 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

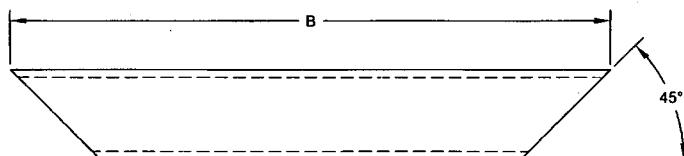
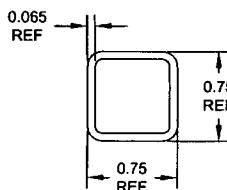
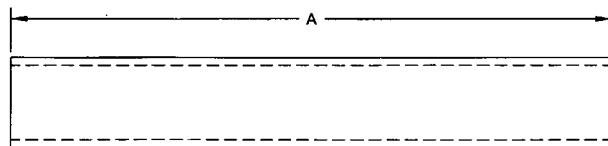
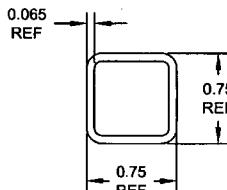
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	_____	25.50	RIB
D2512-3	2	_____	95.30	RIB
D2512-5	6	30.84	_____	RIB
D2512-7	3	30.63	_____	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



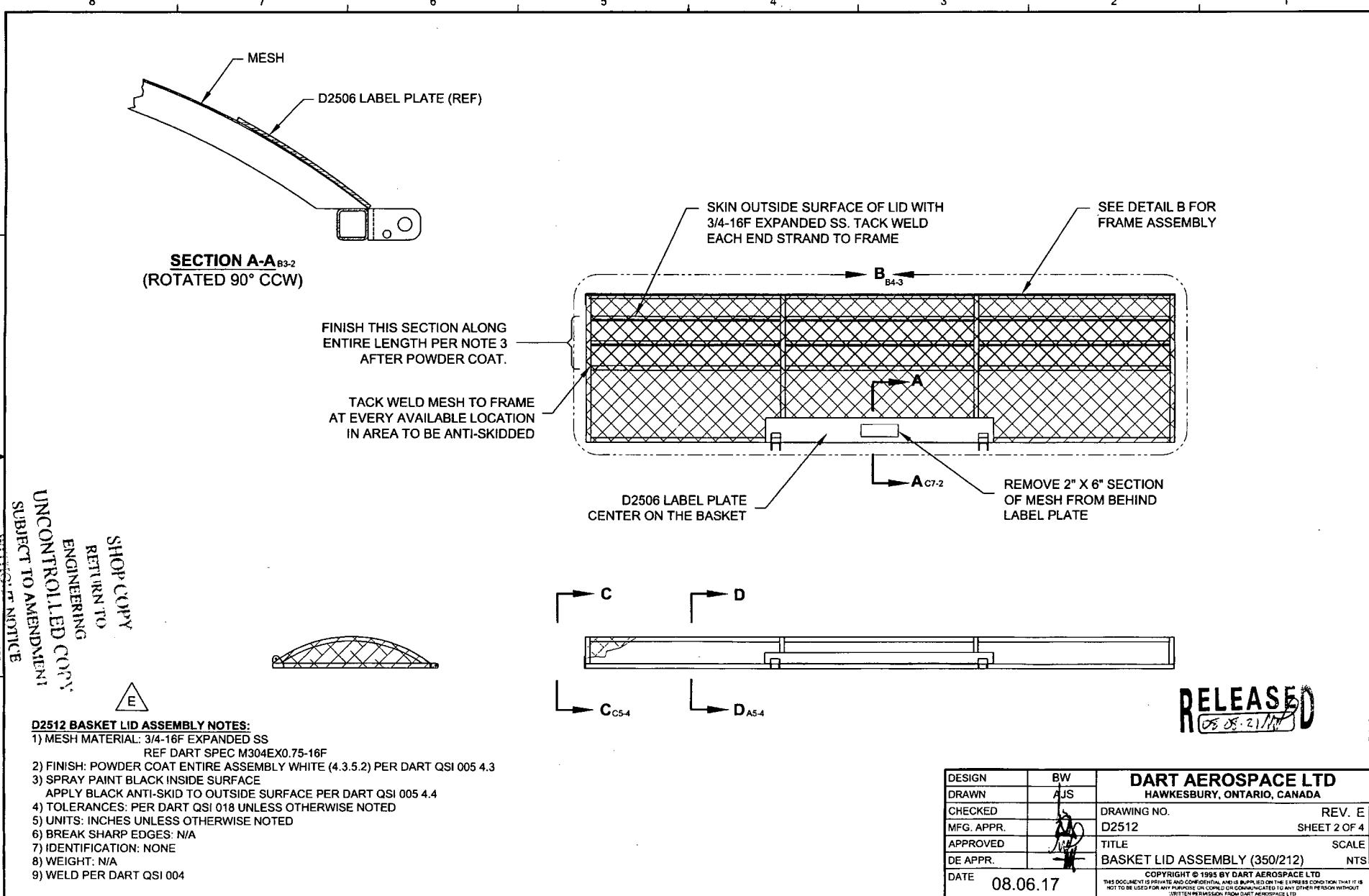
1) INCONTROLD COPY
2) SHOP COPY
3) RETURN TO
4) ENGINEERING
5) SUBJECT TO AMENDMENT
6) WITHOUT NOTICE

D2512-1/3-5/7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M3041S0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

RELEASED
08-08-21-117

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DESIGN	BW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2512 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS
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